

Work Order ID 69488

Wednesday, May 11, 2011 12:56:37 PM

Page 1

Item ID: D3913-041

Accept

Revision ID:

Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011 Start Qty: 1.00

Required Date: 5/13/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 11-05-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3913

A

D4020

A

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: 117884 0.00
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
inspect before welding mesh
2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

11.07.13

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

11.07.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Wednesday, May 11, 2011 12:56:37 PM

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Memo

Quality Control

QC6- Inspect dimensions to drawing

0.00

0.00

8 11-7-14



125



HandFinish

Memo

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

0.00

1

Bl 11-7-14

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Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

Signature: [Handwritten Signature]
Date: 5/11/07/15
Stamp: (V)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Signature: [Handwritten Signature]
Date: 5/10/15

(+0)

170

Identify as per dwg & Stock Location:

G-A

0.00



Packaging

Memo

0.00

Packaging

w/o
69486

Signature: [Handwritten Signature]
Date: 5/11/07/15
Stamp: (V)

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/18
ME
11-07-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Picklist Print

Wednesday, May 11, 2011 12:56:44 PM

Page 1

Work Order ID: 69488

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00


Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581		Manufactured	No			100	Each	38.0000	2	2			
													
Mounting Bracket													

Location

Loc Qty

Loc Code

WA


38

68964

38

69739

2

D3913-1		Manufactured	No			100	Each	4.0000	1	1			
													
Rib													

Location

Loc Qty

Loc Code

WA

2

69260

2

B70346


①

WA006

2

68418

2

D3913-15		Manufactured	No			100	Each	1.0000	1	1			
													
Wide Handle Plate													

Location

Loc Qty

Loc Code

WA005


1

68176

1

B69012

①

D3913-3		Manufactured	No			100	Each	1.0000	1	1			
													
Rib													

Location

Loc Qty

Loc Code

WA006

1

68185

1

B71482 ①

SAD 11-07-08

SAD 11-07-08

SAD 11-07-08

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 69488

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-7 Manufactured No

100

Each

8.0000

2

2



Rib



SAD 11-07-08

Location

Loc Qty

Loc Code

WA006

8

69521

(2)

65278

1

66435

1

68417

6

D3913-9 Manufactured No

100

Each

4.0000

1

1



Hinge Rib



SAD 11-07-08

Location

Loc Qty

Loc Code

WA006

4

B70336

(1)

68186

1

68590

3

D3916-041 Manufactured No

100

Each

4.0000

2

2



Rib Assembly



SAD 11-07-08

Location

Loc Qty

Loc Code

WA

4

B59161

(2)

68538

4

D3916-5 Manufactured No

100

Each

4.0000

3

3



Light Rib



SAD 11-07-08

Location

Loc Qty

Loc Code

WA006

4

68155

4

B59083

(2)

B69076

(1)

W/O:		WORK ORDER CHANGES					
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Work Order ID: 69488

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-1
* 
Hinge Half, Base

Manufactured No 100 Each 28.0000 3 3



SAD 11-07-08

Location

Loc Qty

Loc Code

WA

28

67926

③

66418

0

67473

10

68426

18

D4017-7
/ 
Rib

Manufactured No 100 Each 5.0000 1 1



SAD 11-07-08

Location

Loc Qty

Loc Code

WA

5

B71105


①

68415

2

69009

3

D4017-9
/ 
Rib

Manufactured No 100 Each 10.0000 2 2



SAD 11-07-08

Location

Loc Qty

Loc Code

WA

6

B70341

②

69011

6

WA006

4

68416

4

D4020-11
/ 
End Mesh, Basket

Manufactured No 100 Each 2.0000 2 2



PL 11-07-13

Location

Loc Qty

Loc Code

WA

2

67458

2

B69648 → ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Wednesday, May 11, 2011 12:56:45 PM

Page 4

Work Order ID: 69488

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00


Required Qty: 1.00

D4021-1

 Handle Plate

Manufactured No

100 Each 10.0000 3 3

 SAD 11-07-08

Location

Loc Qty

Loc Code

WA
 68424

10
 10


B6958 (2)
 B6977 (1)

D4034-041

 Aft Upper Rib Assembly

Manufactured No

100 Each 0.0000 1 1


B69157  SAD 11-07-08

D4034-043

 Fwd Upper Rib Assembly

Manufactured No

100 Each 2.0000 1 1

~~B6915~~ B70241  SAD 11-07-08

Location

Loc Qty

Loc Code

WA
 69155


2
 2

M304EX0.75-16F

 Expanded Metal Flat SS

Purchased No

100 sf 518.0152 33 33

 PC 11.07.13

Location

Loc Qty

Loc Code

WA
 115012
 117197
 117455

518.0152
 114
 182.3016
 221.7136

m118153

AN3-10A

 Bolt

Purchased No

150 Each 77.0000 6 6

 ES 5/07/15

Location

Loc Qty

Loc Code

ST351
 117313

77
 77

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Wednesday, May 11, 2011 12:56:46 PM

Page 5

Work Order ID: 69488

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD8 NAS1149DN832J Purchased No

150 Each

0.0000

2

2



Washer

D2931



Bumper

4D M117316 (2)

Manufactured No

150 Each

676.0000

2

2

Location

Loc Qty

Loc Code

ST504

676

46064

676

150 Each

12.0000

2

2

D4021-5

Manufactured No



Blanking Plate

Location

Loc Qty

Loc Code

ST110

10

68261

10

WA005

2

67008

2

150 Each

1,375.000

2

2

MS20600-AD4W3

Purchased No



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1050

111636

350

117505

500

117601

200

WA018

325

107939

325



2 2 5/11/07/15

2 2 5/11/07/15

2 2 5/11/07/15

2

2 2 5/11/07/15

2

W/O:		WORK ORDER CHANGES					
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Wednesday, May 11, 2011 12:56:46 PM

Page 6

Work Order ID: 69488

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

2,328.000

6

6



Nut



5/11/07/15

Location

Loc Qty

Loc Code

ST300

2328

116391

11

116540

351

116549

766

117441

800

117601

400

M117885
(62)

NAS1149F0332P

Purchased

No

150

Each

100.0000

12

12



WASHER



5/11/07/15

Location

Loc Qty

Loc Code

ST275

100

17317

100

M117735
(12)

Wednesday, May 11, 2011 12:56:46 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

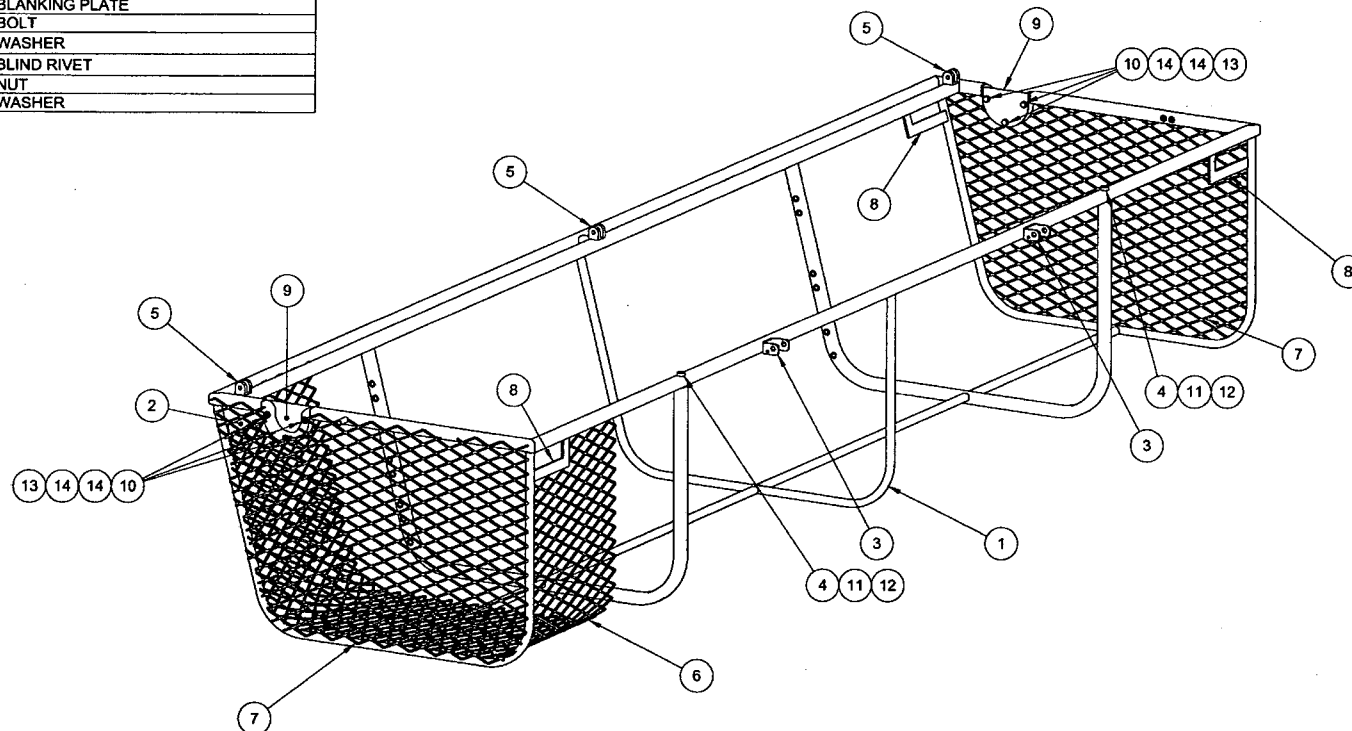
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JFH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3913** REV. A
SHEET 1 OF 6
TITLE **LONG BASKET BASE ASSY (350)** SCALE NTS

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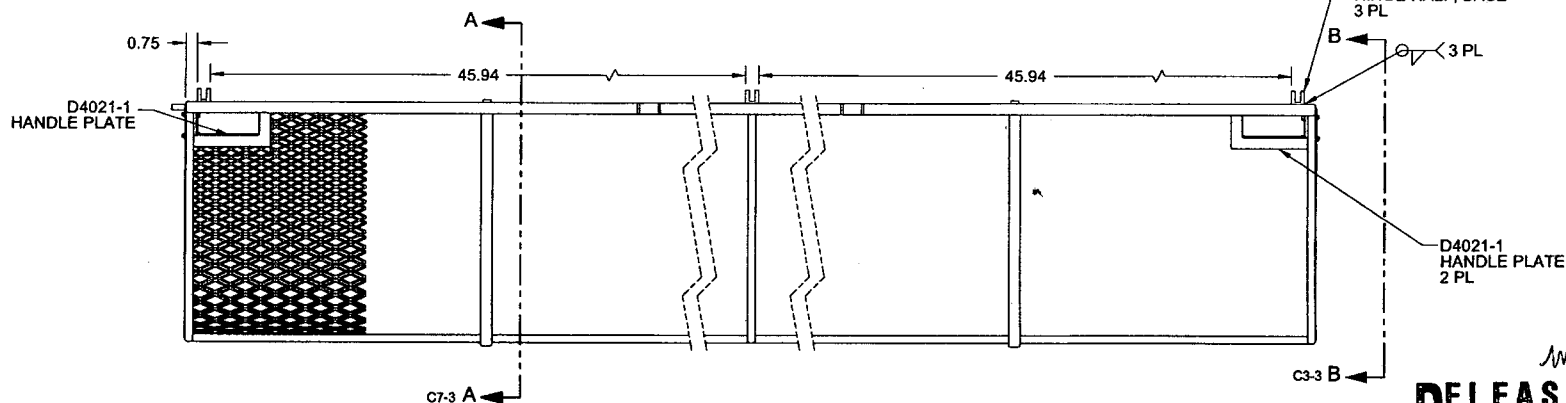
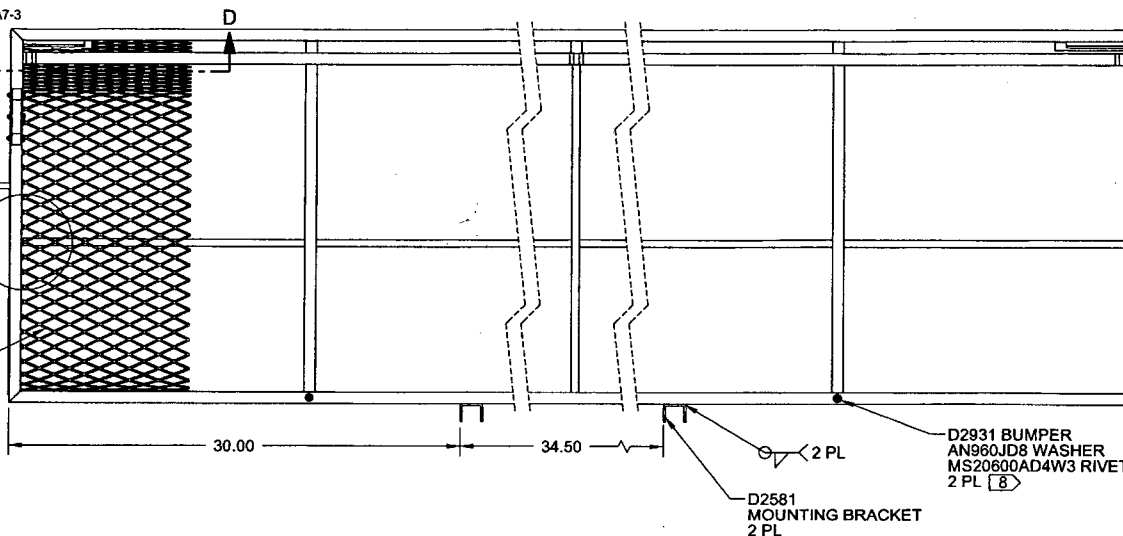
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C 07-2

D A7-3
D
D8-2
D4020-1
MESH



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-02-??

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

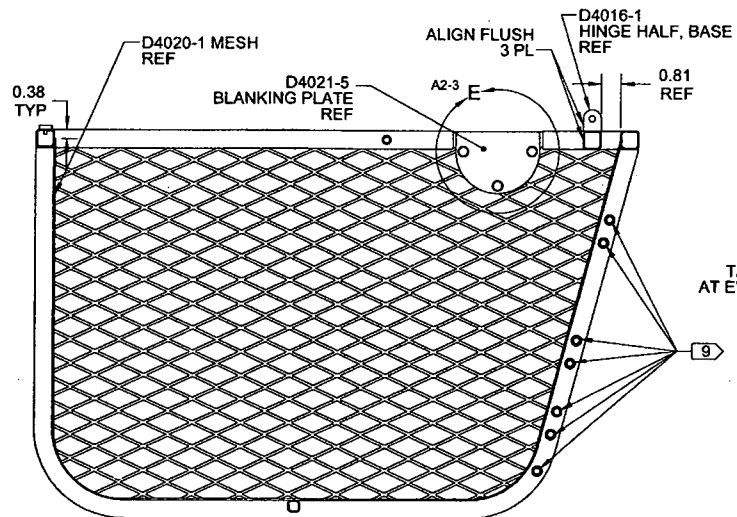
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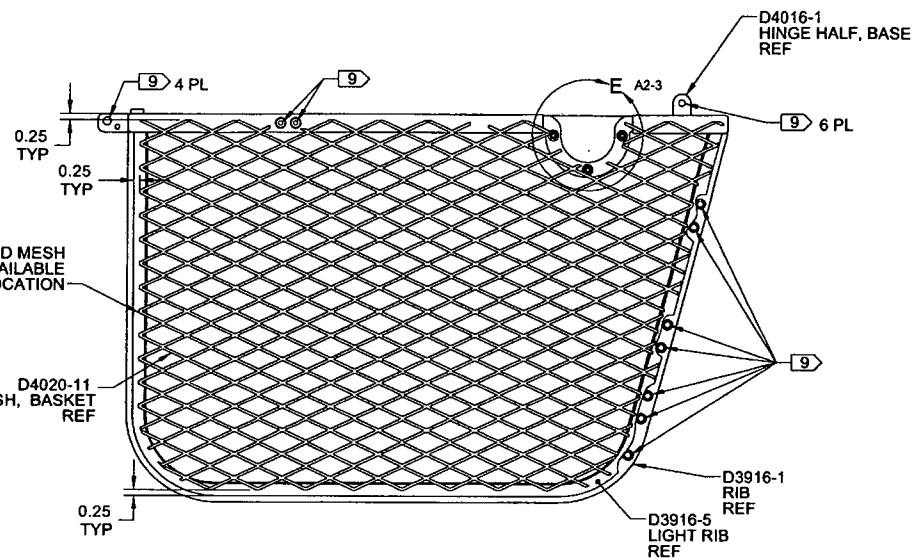
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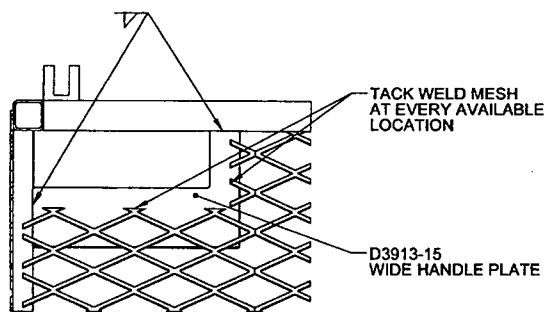
NOTE: Date & initial all entries



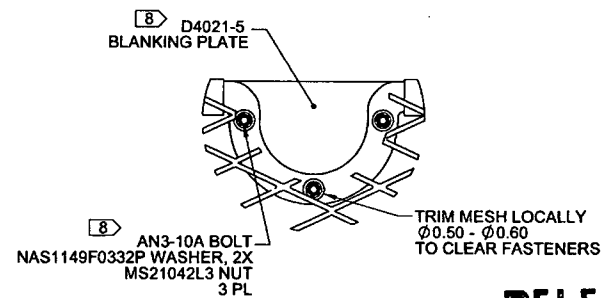
SECTION A-A A5-2



VIEW B-B A2-2







SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

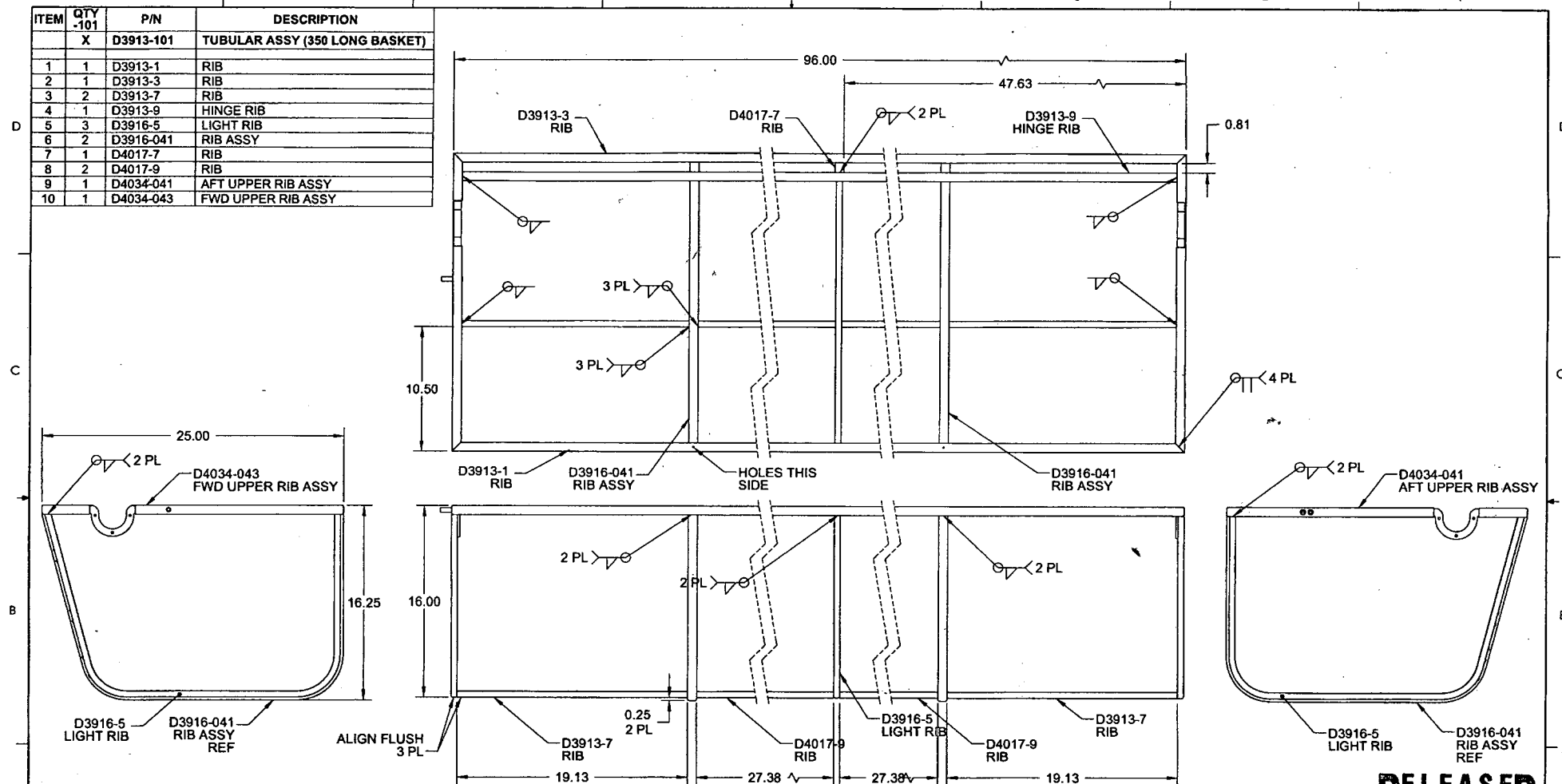
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 8
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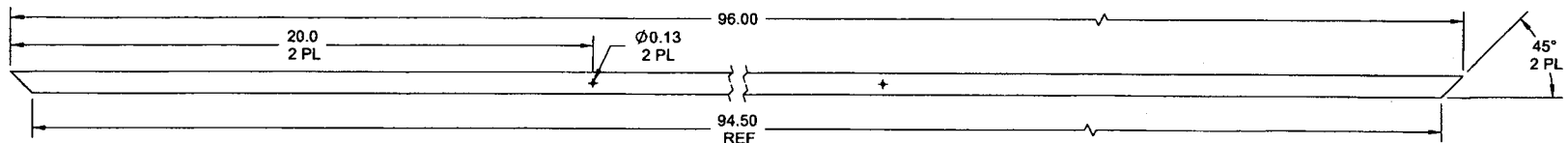
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

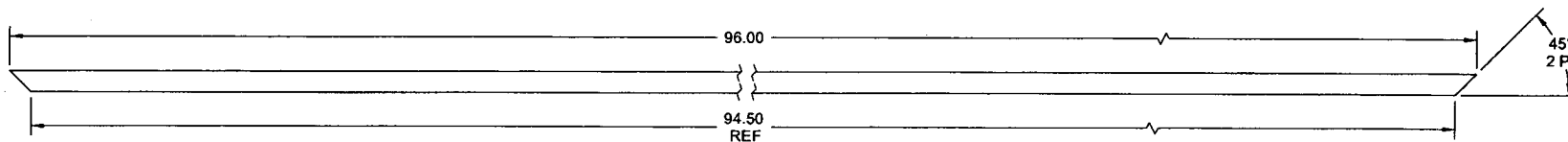
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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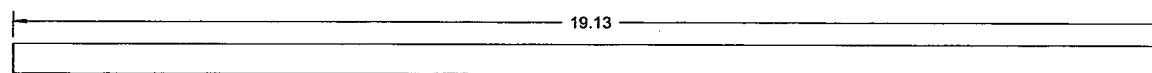
NOTE: Date & initial all entries



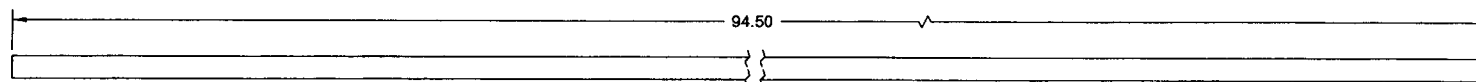
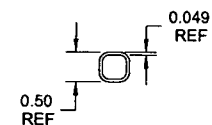
D3913-1 RIB



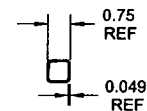
D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB



NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED





4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

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MFG. APPR.		D3913	SHEET 5 OF 6
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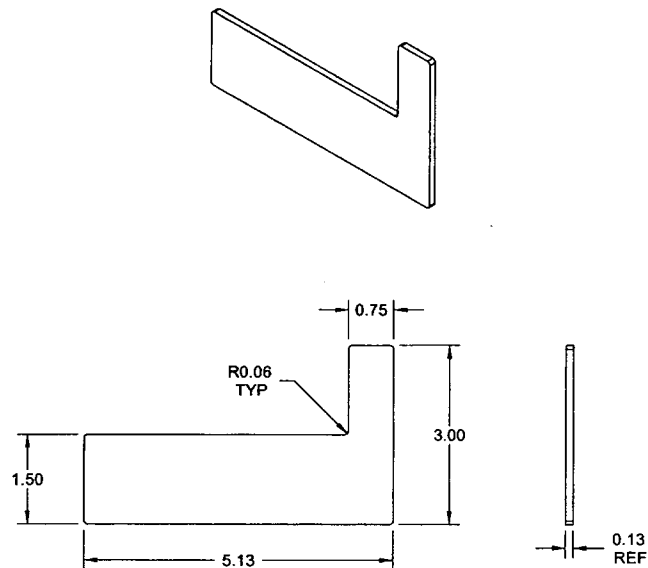
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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